

Work Order ID 144184

144184

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April 06, 2016 10:57:02 AM

Item ID: D350-607-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.
Start Date: 5/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/6/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: SAH Date: 20160405 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	D								
DSI9699	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-541 CHG007								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.01							
Packaging									

MLJ 160616

JUN 17 2016

DAS
28
9-89

JUN 16 2016

DAS
6
9-89
DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Item ID: D350-607-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Stop ***NS2***Start Date: 5/24/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/6/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00					DAS 28 9-89		JUN 17 2016
130 *130* Packaging Packaging	Pick Kit Memo Package as per PPRD350-607-541	0.00 0.00					DAS 27 9-89		JUN 17 2016
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							JUN 17 2016

MLJ JUN 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 144184

144184

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B
11.02.09 add to install label DD verf by:EC IPP REV:C 12.03.06
AS PER ECN12-535 DD VERF:EC IPP REV:D 12.07.24 AS PER
ECN 12-610 DD VERF:EC IPP REV:E 13.08.21 CHG005 / ECN 13-
624 DD VERF:JLM IPP REV:F 14.06.09 AS PER ECN14-572 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No			110	Each	12.0000	1	1			
D4086-200									**				DAS 27 9-89
Placard, Max Load													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST078				12					
				139663				2					
				140764				10					
D4917-300		Manufactured	No			110	Each	14.0000	1	1			
D4917-300									**				DAS 27 9-89
Placard, Max Load													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST137				14					
				138526				4					
				141303				10					
D350-607-511		Manufactured	No			110	Each	2.0000	1	1			
D350-607-511									**				DAS 27 9-89
Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				PK015				2					
				142613				2					

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Work Order ID: 144184

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Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 5/24/2016

Required Date: 6/6/2016

D2690-6	Manufactured	No	110	Each	18.0000	1	1	Start Qty: 1.00	Required Qty: 1.00	DAS 6 9-89
---------	--------------	----	-----	------	---------	---	---	-----------------	--------------------	------------------

D2690-6

Lanyard

**

146036

DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST009	6	
142782	6	
ST012a	12	
142876	12	

D3912-041

Manufactured No

110 Each

4.0000

1

1

D3912-041

Eyebolt Receiver Assy

**

135537

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST057	4	
139441	4	

D4030-041

Manufactured No

110 Each

0.0000

1

1

D4030-041

Long Basket Assembly (350)

**

144185

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

D4151-041

Manufactured No

110 Each

2.0000

1

1

D4151-041

Basket Fwd Hardpoint Assembly, Lower

**

143335

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST087	2	
142675	2	

D4151-043

Manufactured No

110 Each

0.0000

1

1

D4151-043

Basket Fwd Hardpoint Assembly, Upper

**

143358

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

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Work Order ID: 144184

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Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 5/24/2016

Required Date: 6/6/2016

D4150-041

Manufactured No

110

Each

7.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D4150-041

Attachment Arm Assembly

**

143344

DAS
28
9-89

Location

Loc Qty

Loc Code

ST087

7

142612

6

142726

1

AN4-13A

Purchased No

110

Each

506.0000

6

6

AN4-13A

Bolt

**

134754

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

80

m134167

80

O003

300

m134497

300

ST344

106

m134260

106

AN4C15

Purchased No

110

Each

49.0000

1

1

AN4C15

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

12

M134257

12

ST343

37

M1134567

20

M133694

17

~~PRO~~

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DAS
28
9-89

DAS
27
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Work Order ID: 144184

144184

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 5/24/2016

Required Date: 6/6/2016

AN310C4 Purchased No 110 Each 83.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Nut

**

DAS

6

DAS

27

9-89

Location

Loc Qty

Loc Code

OVER007

30

M134370

30

ST331

53

M133604

3

M133990

50

DAS
28
9-89

MS17984-C413

Purchased

No

110

Each

53.0000

1

1

MS17984-C413

Quick Release Pin

**

DAS

DAS 27

6 9-89

9-89

Location

Loc Qty

Loc Code

over005

40

m133686

20

m134052

10

m134528

10

ST315

13

m134029

3

m13462710

10

DAS
28
9-89

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Work Order ID: 144184

144184

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 5/24/2016

Required Date: 6/6/2016

MS21042L4 Purchased No 110 Each 2,482.000 Start Qty: 1.00 Required Qty: 1.00
6 6

MS21042L4

Locknut

**

134762

DAS
6
9-89
DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
FP001	37	
m133363	37	
GA	381	
m133769	381	
OVER007	1000	
m134606	1000	
ST303	967	
m134055	9	
m134502	958	
ST305	97	
m130922	97	

MS24665-151

Purchased No

110 Each

171.0000 1 1

MS24665-151

Cotter Pin

**

DAS
6
9-89
DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
GA	64	
m128401	64	
ST289	107	
m133769	7	
m134294	100	

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Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 5/24/2016

Required Date: 6/6/2016

NAS1515H4L Purchased No 110 Each 341.0000 2 2

Start Qty: 1.00

Required Qty: 1.00

***NAS1515H4I ***

Washer

**

~~137769~~ 131624

DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	22	
103691	2	
m132189	20	
ST260	319	
m132767	19	
m133483	200	
m134376	100	

DAS
6
9-89

NAS1149F0432P Purchased No 110 Each 1,747.000 12 12

NAS1149F0432P

WASHER

**

DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST260a	1000	
M134502	1000	
ST262	626	
M133990	626	
st268	121	
M132677	121	

DAS
6
9-89

NAS1149C0463R Purchased No 110 Each 349.0000 3 3

NAS1149C0463R

Washer

**

DAS
27
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
FP001	70	
m127306	70	
ST260a	200	
m134167	200	
ST266	79	
m133077	79	

DAS
6
9-89

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Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 5/24/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/6/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: SH Date: 20160408 Tooling: _____ Date: _____
OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

[illegible]

DAS
28
9-89

DART AEROSPACE LTD.

REFERENCE ONLY

D350-607-3
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5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				2	2	D3910-5	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L4	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

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Revision: D
Date: 14.01.02